

Work Order ID 52994

October 20, 2009 1:28:35 PM



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Item ID: D2537

Accept



Setup Start



Revision ID: A1

Stop



Item Name: Bushing

Start Date: 10/20/09 Start Qty: 50.00



Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 50.00



Customer:

Reference:Approvals: Process Plan: ✓

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2537	Rev A1

100



Hardinge CNC LATHE SMALL

0.00

*SA 09/10/28**SO ✓*

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Machine as per Folio FA273 □2-Deburr and Tumble

110



QC2- Inspect parts off machine FAI/FAIB

0.00

*SA 09/10/25**SO ✓*

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

*SA 09/10/26**SO ✓*

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**

130



Identify as per dwg & Stock Location:

**Set Up/
Run Hours**
**Draw
Number**
**Draw
Rev.**
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**

Packaging

Memo

0.00

10/20/09 (SC)

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10.09.10.27

*MF**09-10-27*

Picklist Print

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October 20, 2009 1:28:34 PM

Work Order ID: 52994



Parent Item: D2537RevA1



Parent Item Name: Bushing

Start Date: 10/20/09

Required Date: 10/23/09

Comments:

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R.500		Purchased		No		100	f	9.2000	6.0316			

304 SS roundbar .500



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

MAT	9.2
108415	2
111323	7.2

687 SA 09/10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QA COPY
0303

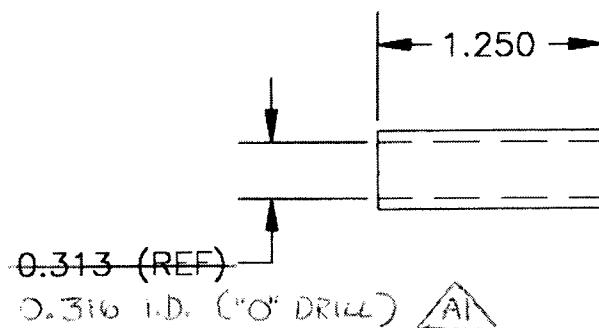
DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>M. M.</i>	APPROVED <i>B.W.</i>	DRAWING NO. D2537	REV. A SHEET 1 OF 1
DATE 96:05:15		TITLE BUSHING	SCALE 1:1

RELEASED
960712 6 PM

A1 02.09.30 (P) 0.316 WAS 0.313

QA COPY
0303

vp 5294



MATERIAL: 304/316 SS 7/16 OD 0.063 WALL

OR 0.065 WALL

KE 29.07.07

DART AEROSPACE LTD	Work Order:	52944
Description: Bushing	Part Number:	D2537
Inspection Dwg: D2537	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>SD</u>	Audited by:	<u>ANL</u>	Prototype Approval:	N/A
Date:	<u>05/10/25</u>	Date:	<u>09/10/26</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	
B	05.02.17	Added Ø0.438	KJ/JLM	
C	07.10.31	Tolerance revised on Ø0.438	KJ/EC/DD	14 DS